

Work Order ID 65704

January 24, 2011 8:47:29 AM

Page 1

Item ID: D3407-041

Revision ID:

Item Name: Tow Ring

Start Date: 1/24/11 Start Qty: 12.00

Required Date: 2/11/11 Req'd Qty: 12.00

Reference:


Approvals: Process Plan: U Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start
Stop


Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------


Draw Nbr	Revision Nbr
D3407	Rev E

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 A/R TIG174 ROD Batch: <u>M101972</u>								

2 11-3-4 (X13)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
									
QC	Memo	0.00							
Quality Control									

Ppl 11.03.05

120	QC5- Inspect part completeness to step on W/O	0.00							
									
QC	Memo	0.00							
Quality Control									

8/10/07

(X13)

DRAB
GREEN
13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65704

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Page 2

Item ID: D3407-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Tow Ring

Start Date: 1/24/11 Start Qty: 12.00

Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

~~130~~ 125

~~White Gloss (Ref: 4.3.5.2) per QS1005 4.3-Steel~~

~~0.00~~

Drab Green (Ref: 4.3.5.11) per QS1005 4.3).



Powdercoat

Memo

0.00

Powder Coating

Mask Threaded Section

START TIME: 11:00

OVEN TEMPERATURE: 320°

FINISH TIME: 8:30

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

13. 11-3-8.

13 4 MU 11/3/08

14/3/8 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65704

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Page 3

Item ID: D3407-041

Accept

Revision ID:

Item Name: Tow Ring

Start Date: 1/24/11 Start Qty: 12.00

Required Date: 2/11/11 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/08 *[Signature]**MF*
11-03-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

January 24, 2011 8:47:28 AM

Page 1

Work Order ID: 65704

Parent Item: D3407-041

Parent Item Name: Tow Ring



Start Date: 1/24/11

Required Date: 2/11/11

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 05.10.14 New issue KJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3407-1 Stem		Manufactured	No			100	Each	16.0000	1	12			
-----------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

Location Loc Qty Loc Code

WA 16
63580 16

D3407-5 Ring		Manufactured	No			100	Each	6.0000	1	12			
-----------------	--	--------------	----	--	--	-----	------	--------	---	----	--	--	--

Location Loc Qty Loc Code

WA 6
64453 6
65705 9
66556 4

EL 11-3-3

13
EL 11-3-3

9
4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

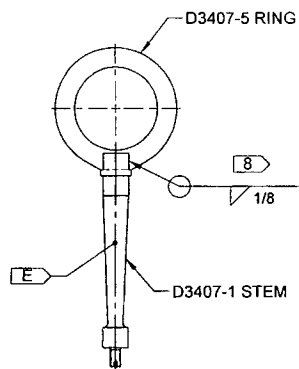
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

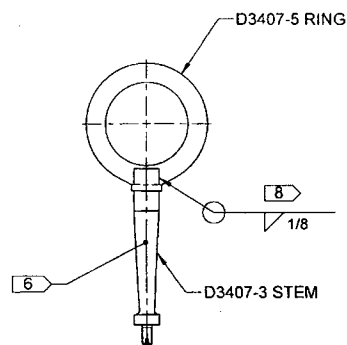
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

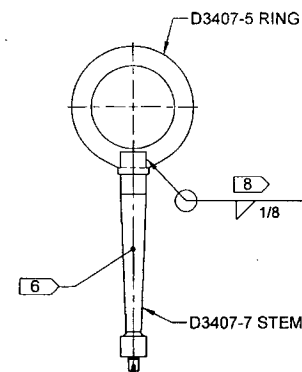
QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM



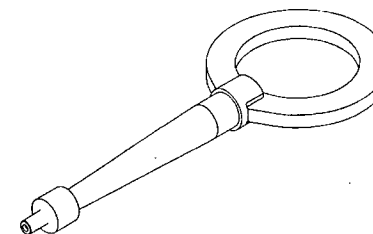
D3407-041 TOW RING



D3407-043 TOW RING



D3407-045 TOW RING

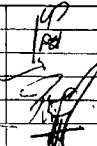


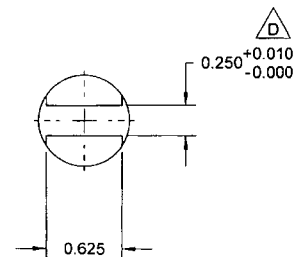
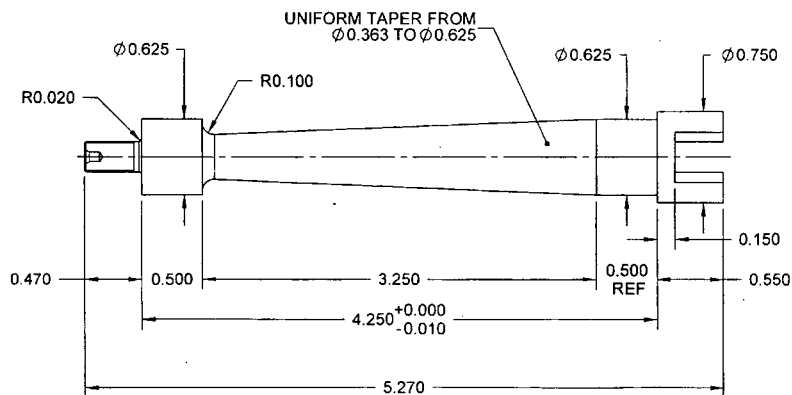
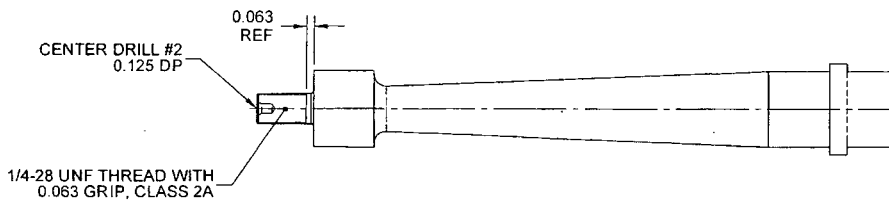
RELEASED

WLO 6/27/04

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
- 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.	TOW RING	NTS	
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



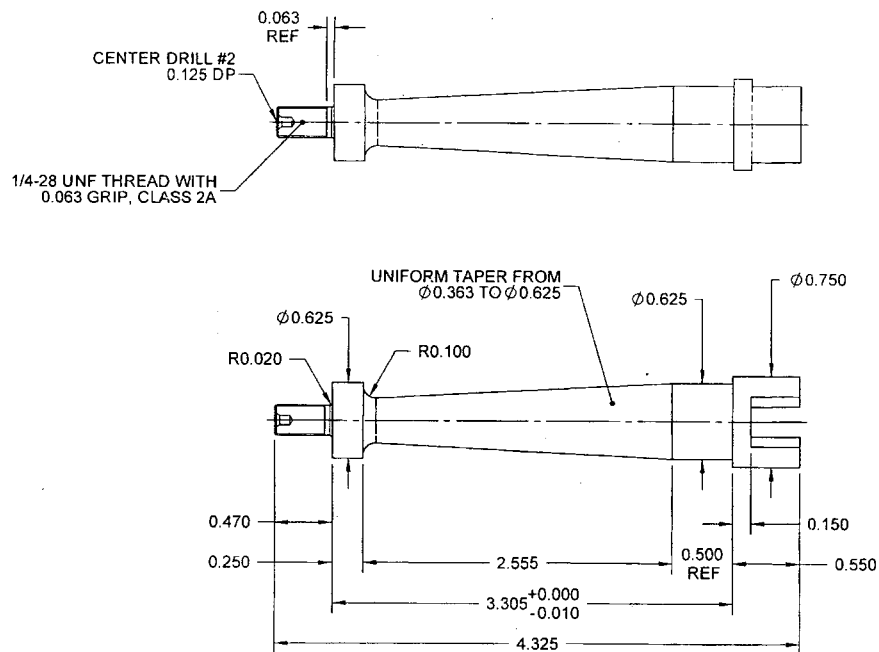
D3407-1 STEM

65704

RELEASED

- NOTES:
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.33 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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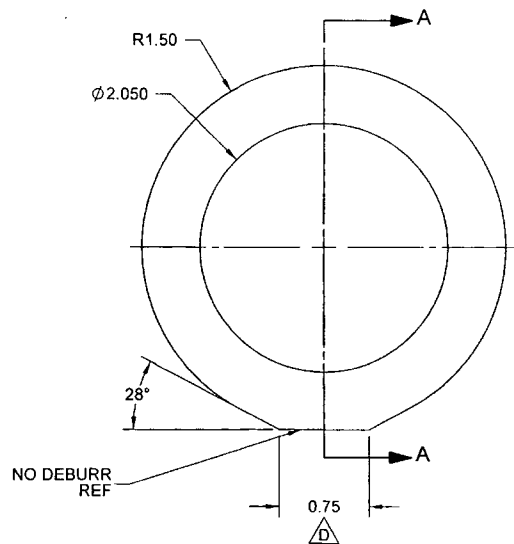
D3407-3 STEM

NOTES:

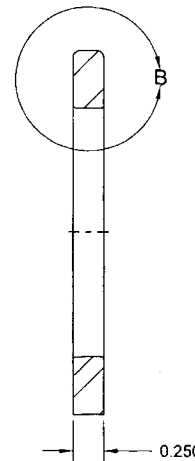
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

RELEASED
01-03-01 RLP

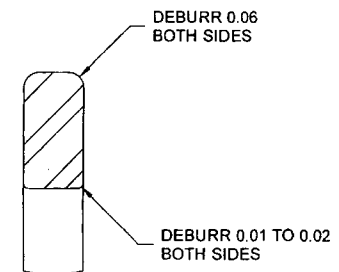
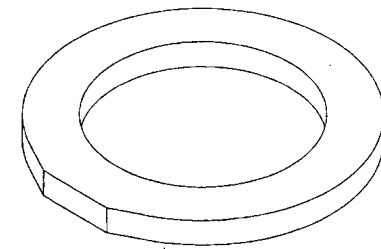
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG APPR.		D3407	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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D3407-5 RING



SECTION A-A



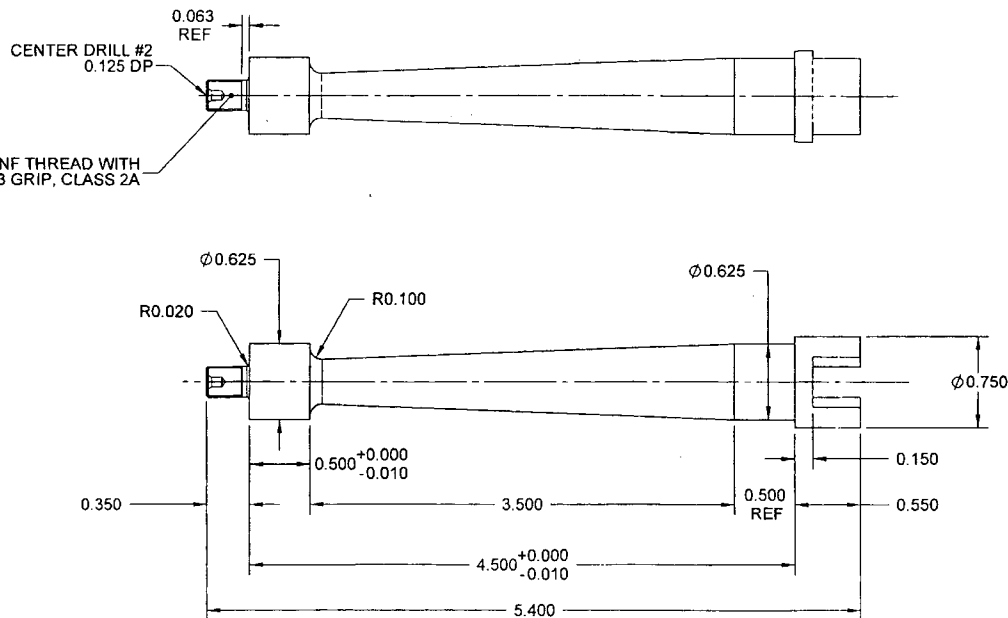
**DETAIL B
SCALE 2X**

RELEASED
00-00-0111

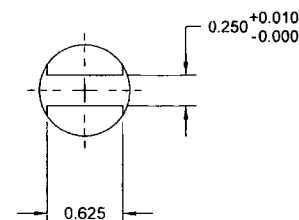
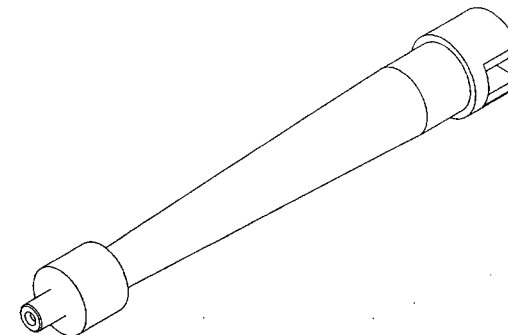
- NOTES:**
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.27 lbs

65704

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	Per	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
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D3407-7 STEM



- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.34 lbs

65704

RELEASED

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	JF	PORT HADLOCK, WA	
CHECKED	JF	DRAWING NO.	REV. E
MFG. APPR.	JF	D3407	SHEET 5 OF 5
APPROVED	JF	TITLE	SCALE
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